

Work Order ID 73392

Wednesday, August 31, 2011 3:03:55 PM



Page 1

Item ID: D2652

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 8/31/2011 Start Qty: 160.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 160.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/08/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2652

Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA252 & DWG D2652 FOLIO
REV: 1/2 DWG REV: A 2-DEBURR AS REQUIRED

SA 11/9/26

160

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 11/9/26

160

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Debur 11/9/27

count
4160

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73392

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Page 2

Item ID: D2652

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 8/31/2011 Start Qty: 160.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 160.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *stl9.*

0.00



Packaging

Memo

0.00

Packaging

8/11-09-28

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/28

ME 11-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, August 31, 2011 3:03:53 PM

Page 1

Work Order ID: 73392



Parent Item: D2652

Parent Item Name: Bushing

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP Rev:B 02.06.13 Now machined in house. NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500		Purchased	No			100	f	35.9300	.06	9.6	9.6		
										9.263158		8/19/26	
303 Round Bar 0.500"													

Location	Loc Qty	Loc Code
MAT028	35.93	
117143	11.34	
118271	11.9	
118509	12.69	

M 119009

9.6 Pt

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

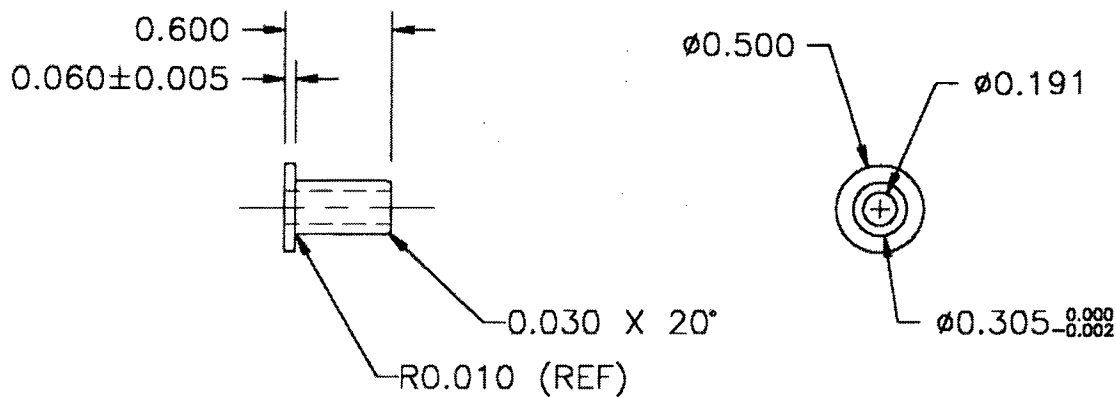
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2652	REV. A SHEET 1 OF 1
DATE 97:03:25		TITLE BUSHING	SCALE 1:1

RELEASED
97/04/25 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73392

CL11108131

MATERIAL: AISI 303 SS
NOTE: BREAK ALL SHARP CORNERS 0.010 MAX
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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